

Work Order ID 116985

D2842-042

116985

Page 1

June-13-14 7:43:13 AM

B116985

Item ID: D2842-042

REV-B

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Assembly RH, 206 Float

Start Date: 4/23/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/23/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2842

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8272 as per Dwg D2842 ***DO NOT OPEN
HOLES***
3-Deburr and bevel ends for welding

4 x

DMC 14-7-10

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

4

d

SSS
14-7-15

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Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly RH, 206 Float
 Start Date: 4/23/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>128385</u> Large Fab	0.00				4			DAS 24 9-89
	Memo	0.00							
	1-Weld one end cap and (2) lugs using DT10058 as per Dwg D2842								
	2- OPEN HOLES TO SIZE AS PER DWG								
	3-Grind end cap weld flush								
120 *120* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
	Quality Control								
130 *130* QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

CPC 14-7-24

(4) 1407-24 DAS 9 9-89

(1) 1407-24 DAS 9 9-89

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Item ID: D2842-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly RH, 206 Float

Start Date: 4/23/14 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						4		14-7-24	DMC
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00				4	0		
150									
QC	Memo	0.00							
Quality Control									
160	Weld per dwg A/R Aluminum rod Batch: M12507/	0.00				4	0		
160	Large Fab								
Large Fab	Memo	0.00							
	1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.								
	DMC								
	14-07-28								

DAS
19
9-89

14-07-28

14-07-28

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Item ID: D2842-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly RH, 206 Float

Start Date: 4/23/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC10- Inspect visual per QSI004- ground welds

0.00

EB
14/07/29DAS
16
9-89

170

QC

Memo

0.00

Quality Control

(4) RH

180

QC5- Inspect part completeness to step on W/O

0.00

EB
14/07/29DAS
16
9-89

180

QC

Memo

0.00

Quality Control

(4) RH

185

Pressure Wash per QSI005 4.3

0.00

185

HandFinish

Memo

0.00

Hand Finishing

Touch up step with alodine per qsi 005 prior to powder coat

(4) RH DMC 14-07-29

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Item ID: D2842-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly RH, 206 Float
 Start Date: 4/23/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
190									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:50 OVEN TEMPERATURE: 325 FINISH TIME: 11:20								
200	QC3- Inspect Part Finish	0.00							
200									
QC	Memo	0.00							
Quality Control									
210	HandFinishing	0.00							
210									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: 14129693								

4 _____ CL 14-07-30

X4B+1 _____ d _____ 15 8:00

4 X4B+1 _____ d _____ 14/07/30

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Item ID: D2842-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly RH, 206 Float
 Start Date: 4/23/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

QC5- Inspect part completeness to step on W/O

0.00

16

9-89

0.00

14/02/06

220

QC

Memo

Quality Control

230

Identify as per dwg & Stock Location: _____

0.00

230

Packaging

Memo

PPP123173

0.00

Packaging

4a 8 14-08-07

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

MLJ 14-08-11

14-8-8

Picklist Print

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Work Order ID: 116985

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Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

110

Each

91.0000

1

4

D2622-120C

Step Extrusion

**

DMC 14-7-10

Location

Loc Qty

Loc Code

HALL

32

109575

32

WA003

59

101765

1

115141

58

D2734

Manufactured No

110

Each

123.0000

2

8

D2734

Step End Plate

**

Cpl 14-7-24

Location

Loc Qty

Loc Code

WA003

123

119286

86

119498

36

99709

1

D3459-1

Manufactured No

110

Each

9.0000

2

8

D3459-1

Float Step Mounting Plate

**

Cpl 14-7-24

Location

Loc Qty

Loc Code

WA003

9

113244

9

NO MORE

12/1/20 → 1

Picklist Print

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Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 4.00

Required Qty: 4.00

D3459-3 Manufactured No

210 Each 14.0000 2 8

D3459-3

Float Step Mounting Plate

**

Cpl 14.7.24

Location

Loc Qty

Loc Code

WA003

14

113052

14

210

Each

83.0000

3

12

**

all 4/10/13

MS27039C1-07

Purchased No

MS27039C1-07

screw

Location

Loc Qty

Loc Code

ST308

83

124580

6

m127305

27

m128401

50

100

Each

5,228.000

3

12

**

all 4/10/13

NAS1149C0332R

Purchased No

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

GA

809

125654

809

Return2014

41

122063

41

ST279

600

m129390

600

ST292

628

125654

8

m128591

620

st510

3150

m126319

61

m127306

2500

m127410

563

m127831

26

M1129909

412

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Shop Packet Print

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Picklist Print

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Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 4.00

Required Qty: 4.00

NAS1329C3KB130

Purchased

No

210

Each

76.0000

3

12

NAS1329C3KB130

del 4/23/14

Insert

Location

Loc Qty

Loc Code

FP001

51

m126410

1

m127836

50

ST

25

x12

296

25

NAS1515H3L

Purchased

No

210

Each

467.0000

3

12

***NAS1515H3I ***

del 4/23/14

Washer

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

427

m127831

155

m128976

272

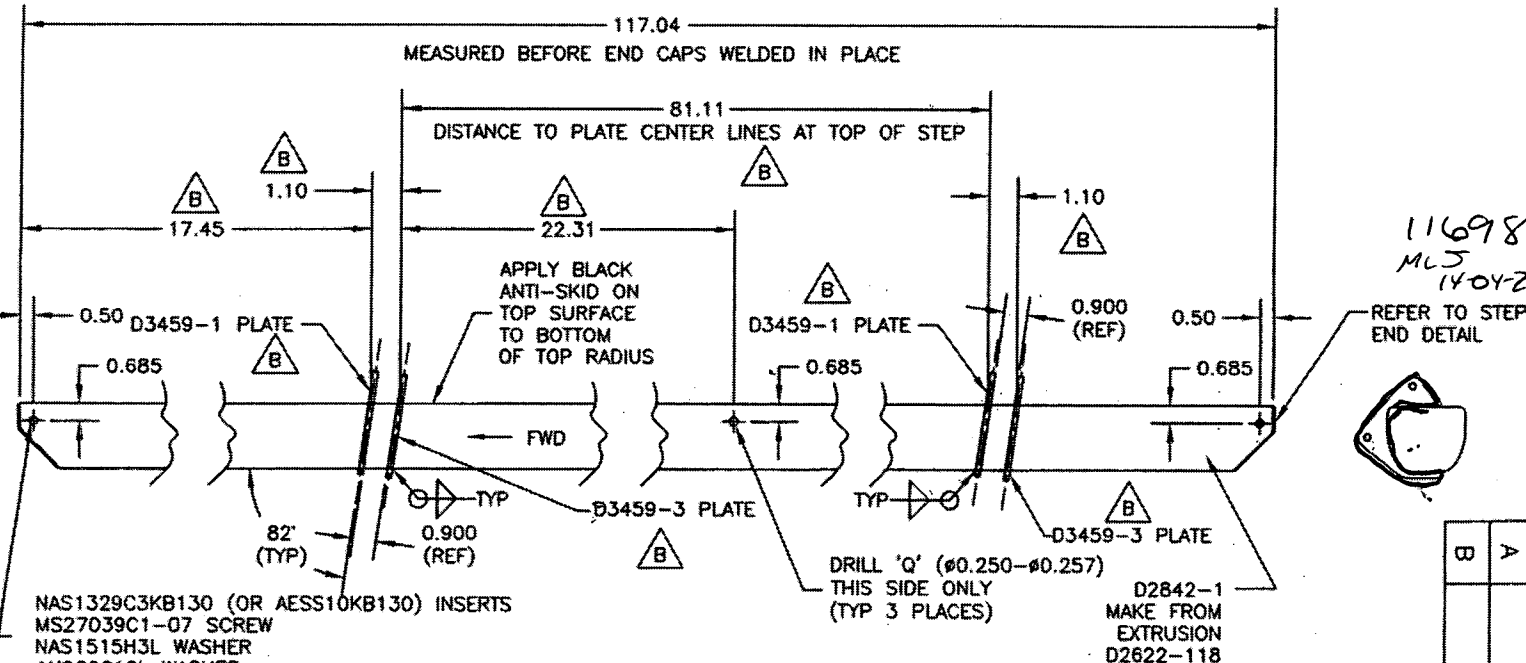
x12

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Shop Packet Print

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DART



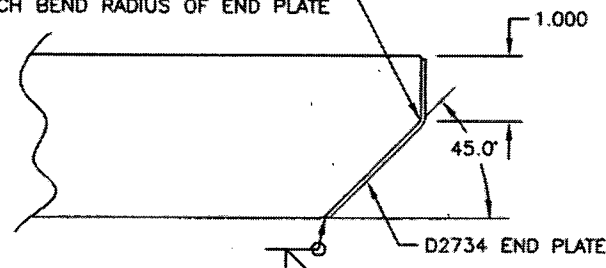
NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-11-14

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DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	RE-DESIGN, ADD D3459-1/-3
	A	98.10.13	NEW ISSUE	
	B	05.09.23	2061/407 FLOAT STEP ASSEMBLY	
			SHEET 1 OF 1	
			SCALE	